

Work Order ID 142639

Friday, March 11, 2016 9:57:47 AM

646.3001
B142639
REV. N/C

142639

Page 1

Item ID: 646.3001

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lower Cutter Assy

Start Date: 3/28/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MUS Date: MAR 11 2016 Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.3000	N/C

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

MAY 25 2016

DAS
6
9-89

120 0.00

120

Small Fab Memo 0.02

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.

A/R RTV LOCTITE 598: 435047
exp. date: 01/18

24 16/07/28 36 89 DAS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Picklist Print

Friday, March 11, 2016 9:57:47 AM

Page 1

Work Order ID: 142639

142639

Parent Item: 646.3001

646 3001

Parent Item Name: Lower Cutter Assy

Start Date: 3/28/2016

Required Date: 4/8/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21042L08

Purchased

No

Each

1,645.000

38

MS21042L 08

Nut

16/07/27 DAS
36
9-89

Location

Loc Qty

Loc Code

CA	101	
m129682	101	
GA	161	
m133134	3	
m134063	158	
OVER007	500	
m134063	500	
ST303	483	
m133922	483	
ST308	400	
m134376	400	

38

102 646.3010

Manufactured

No

110

Each

0.0000

1

2

646 3010

LH Half

646.3011

Manufactured

No

110

Each

9.0000

1

2

646 3011

RH Half

142330X1

142499

142473

Location

Loc Qty

Loc Code

cck102	9	
126778	3	
136653	6	

DAS
6
9-89

DAS
6
9-89

MAY 25 2016

DQA: _____ Date: _____



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Picklist Print

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Page 2

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Parent Item: 646.3001

646.3001

Parent Item Name: Lower Cutter Assy

Start Date: 3/28/2016

Required Date: 4/8/2016

Start Qty: 2.00

Required Qty: 2.00

646.3012

Manufactured No

110

Each

8.0000

1

2

646.3012

Lower Guide

**

141006

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK013

8

136147

8

646.3013

Manufactured No

110

Each

8.0000

1

2

646.3013

Blade

**

142489

DAS
6
9-89

Location

Loc Qty

Loc Code

cck103

8

140566

8

646.3014

Manufactured No

110

Each

9.0000

1

2

646.3014

Blade

**

142467

DAS
6
9-89

Location

Loc Qty

Loc Code

cck103

9

140561

9

646.3015

Manufactured No

110

Each

11.0000

1

2

646.3015

Blade

**

2

DAS
6
9-89

Location

Loc Qty

Loc Code

cck103

11

140185

11

MAY 25 2016

DQA: _____ Date: _____



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		OTHER : ☐																																																																			

Picklist Print

Friday, March 11, 2016 9:57:47 AM

Page 3

Work Order ID: 142639

142639

Parent Item: 646.3001

646 3001

Parent Item Name: Lower Cutter Assy

Start Date: 3/28/2016

Required Date: 4/8/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

1,040.000

19

38

MS27039-08-19

Screw

DAS
36
9-89
16/07/27

Location

Loc Qty

Loc Code

CCK06

200

m134142

200

GA

677

m132930

84

m133077

22

m134063

571

over006

100

m134294

100

ST277

63

m133769

63

NAS1149FN832P

Purchased

No

110

Each

3,671.000

38

76

NAS1149FN832P

Washer

DAS
36
9-89
16/07/27

Location

Loc Qty

Loc Code

GA

1361

M133316

16

M133769

1345

ST260a

1200

M134257

1200

ST262

1110

M133709

1110

50

M135058
260

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

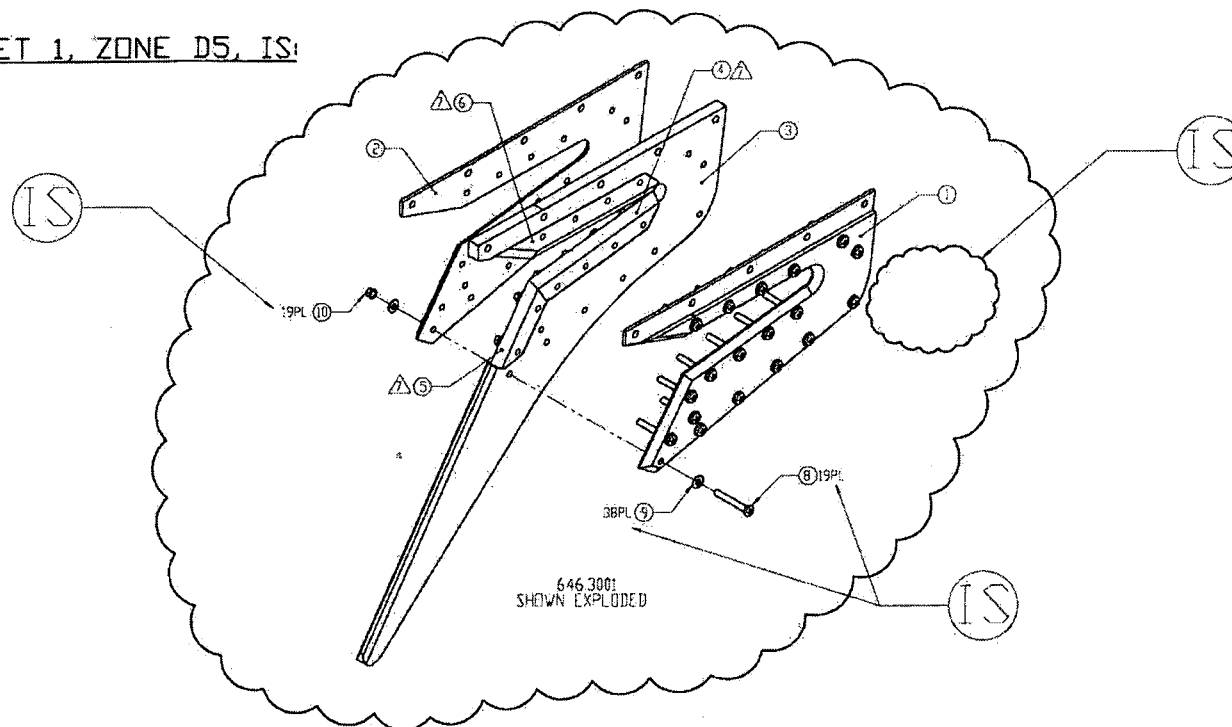
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																											
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																																																												
Description Work Order Deviation				Disposition				Completed By																																																																																											
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OTHER : _____																																																																																																			

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO.		02195		SHEET 1 OF 4	
	DWG NO.	646.3000	REV: N/C	PREPARED BY	S. HUFF	DATE: 01/05/09
	DWG TITLE:		LOWER CUTTER ASSY			
	APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF:	NEXT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS				

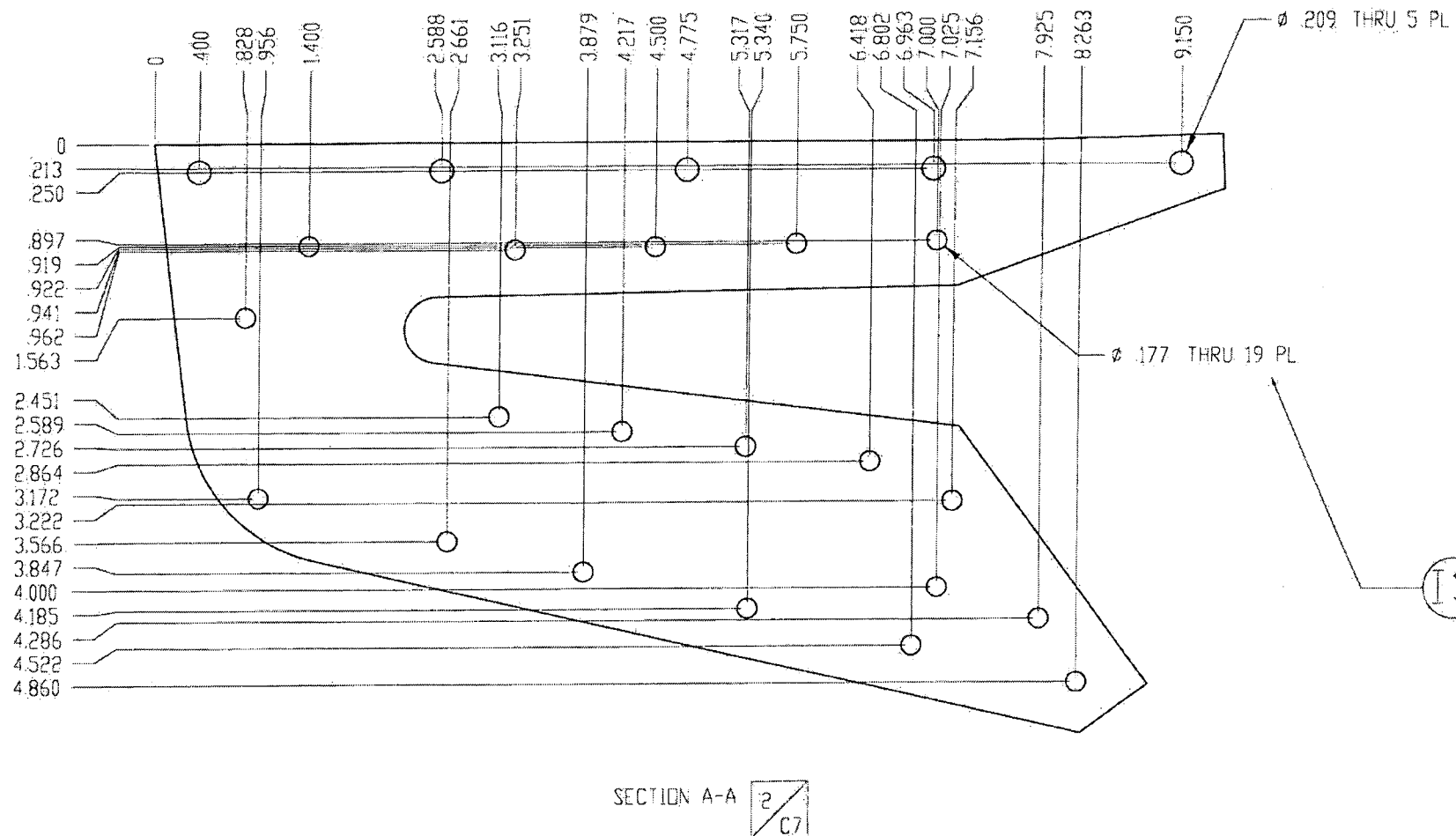
SHEET 1, ZONE D5, IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142639 MJS
16-03-11

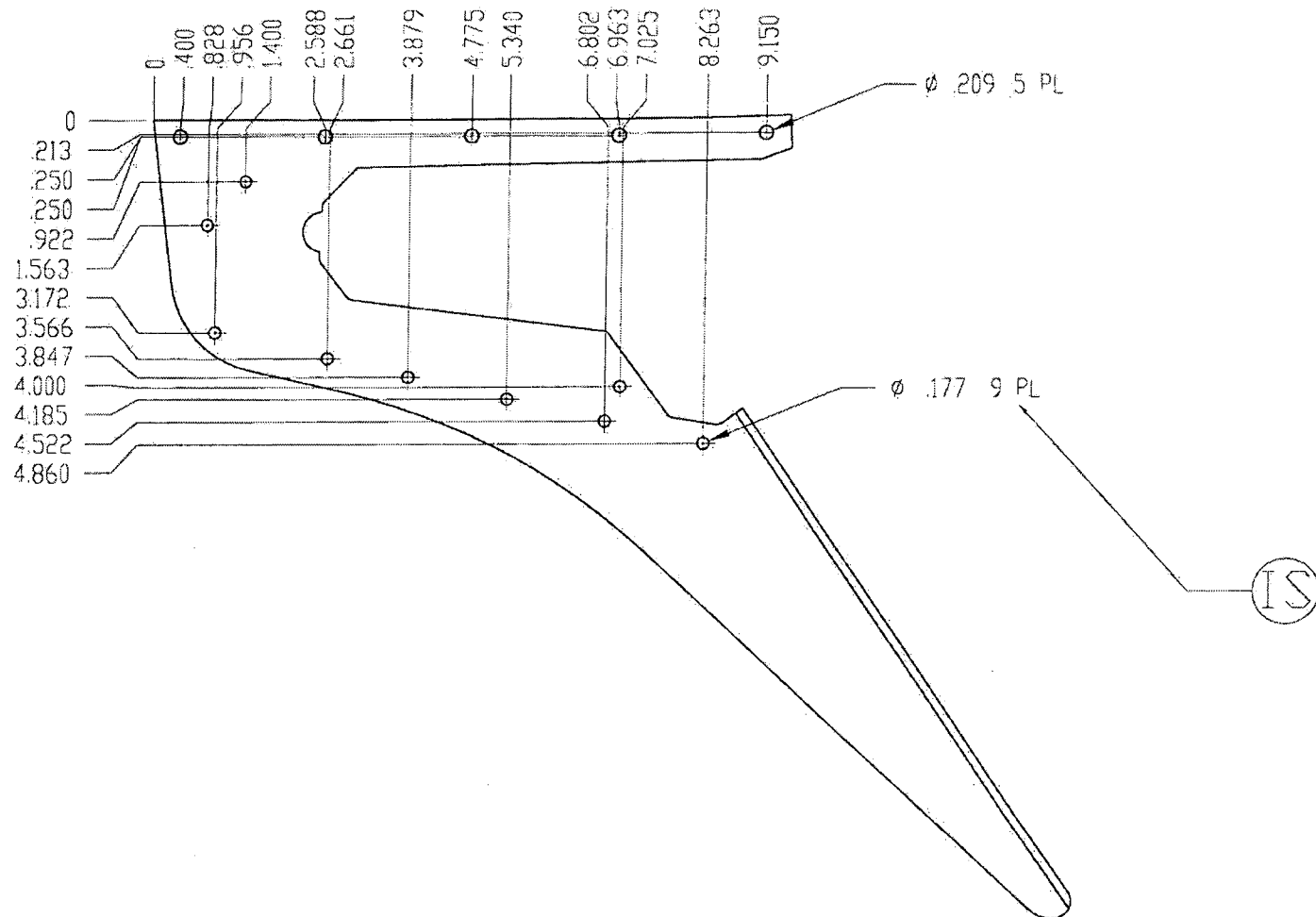
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9	R	601.2764	38	WASHER	NAS1149FN832P
8	R	601.2765	19	SCREW	MS27039-0819
7	D	601.2766	2	RIVET	MS20470AD5-18
			.3001		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR
				DER REVIEW REQUIRED ☐ YES ☒ NO	

SHEET 3 IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 5 IS:

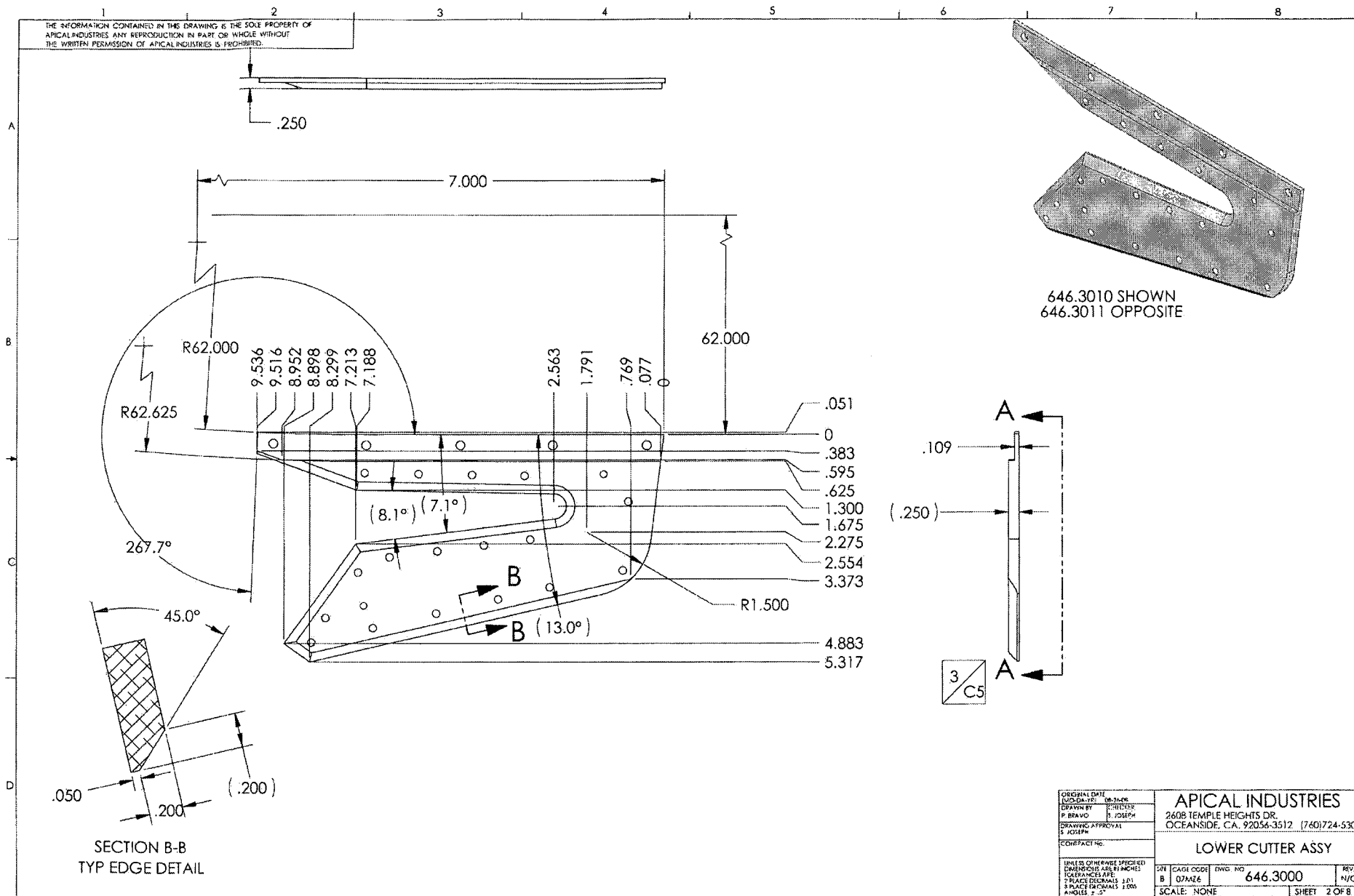


SECTION F-F 4
B6

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET B	CAGE CODE 07MZ6	DWG. NO 646.3000	REV N/C
SCALE NONE		SHEET 1 OF 8	

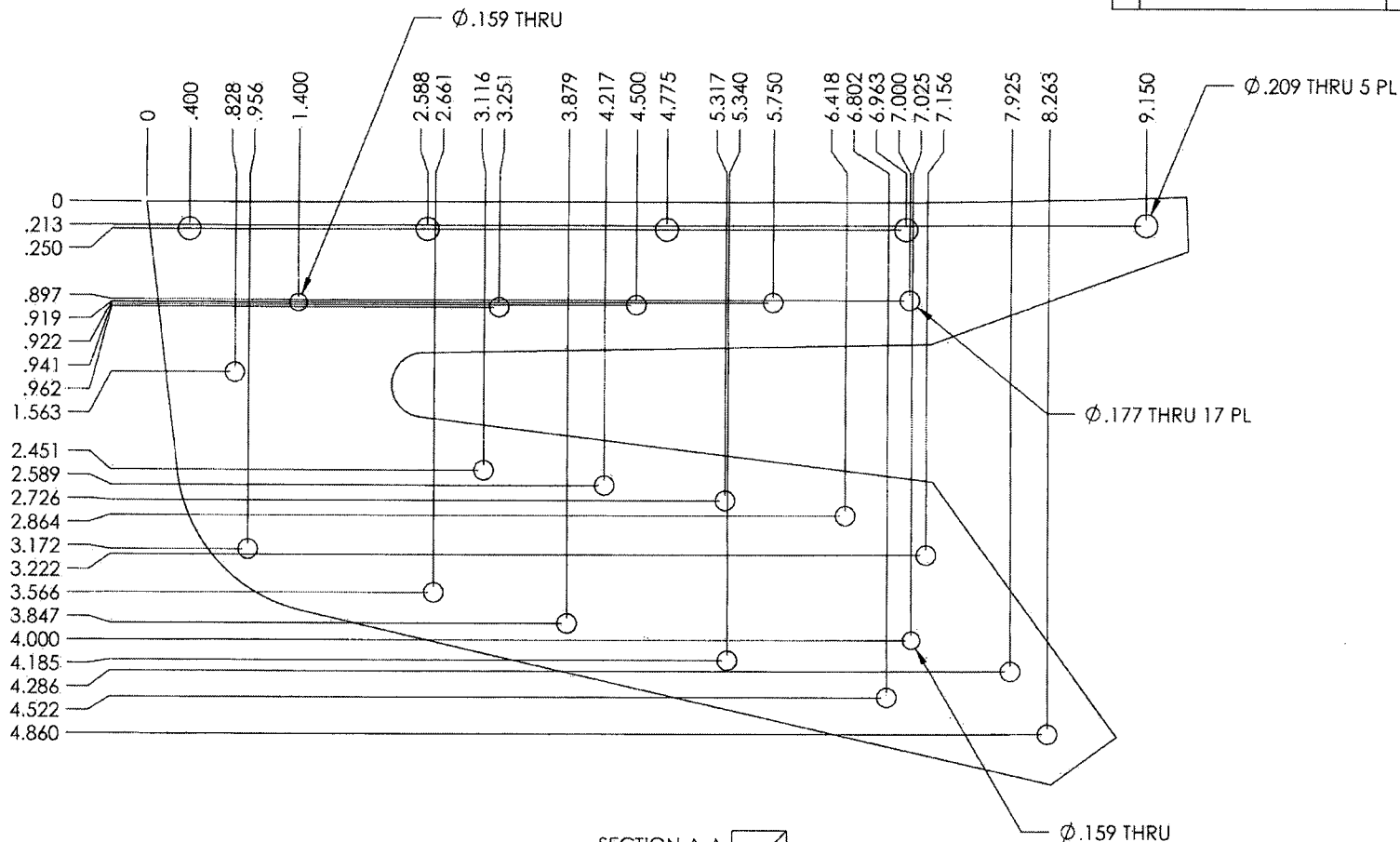
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



ORIGINAL DATE (DD/DA/YY) 08-24-96		APICAL INDUSTRIES	
DRAWN BY P. BRUNO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY S. JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .01 HOLDING TOLERANCES .005 ANGLES 2.5°		SITE CODE B 07ANZ6	REV. N/C
		DWG. NO. 646.3000	SHEET 2 OF 8
		SCALE: NONE	

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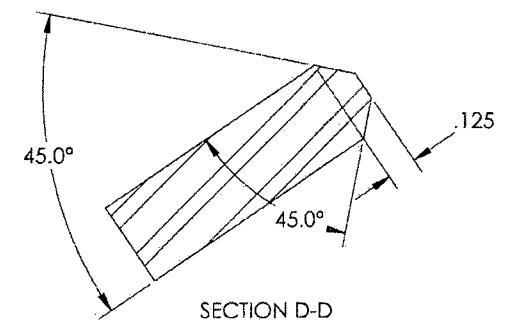
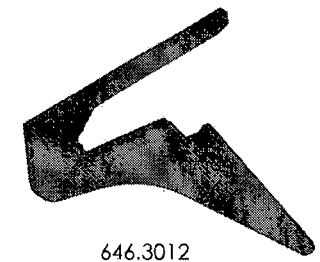
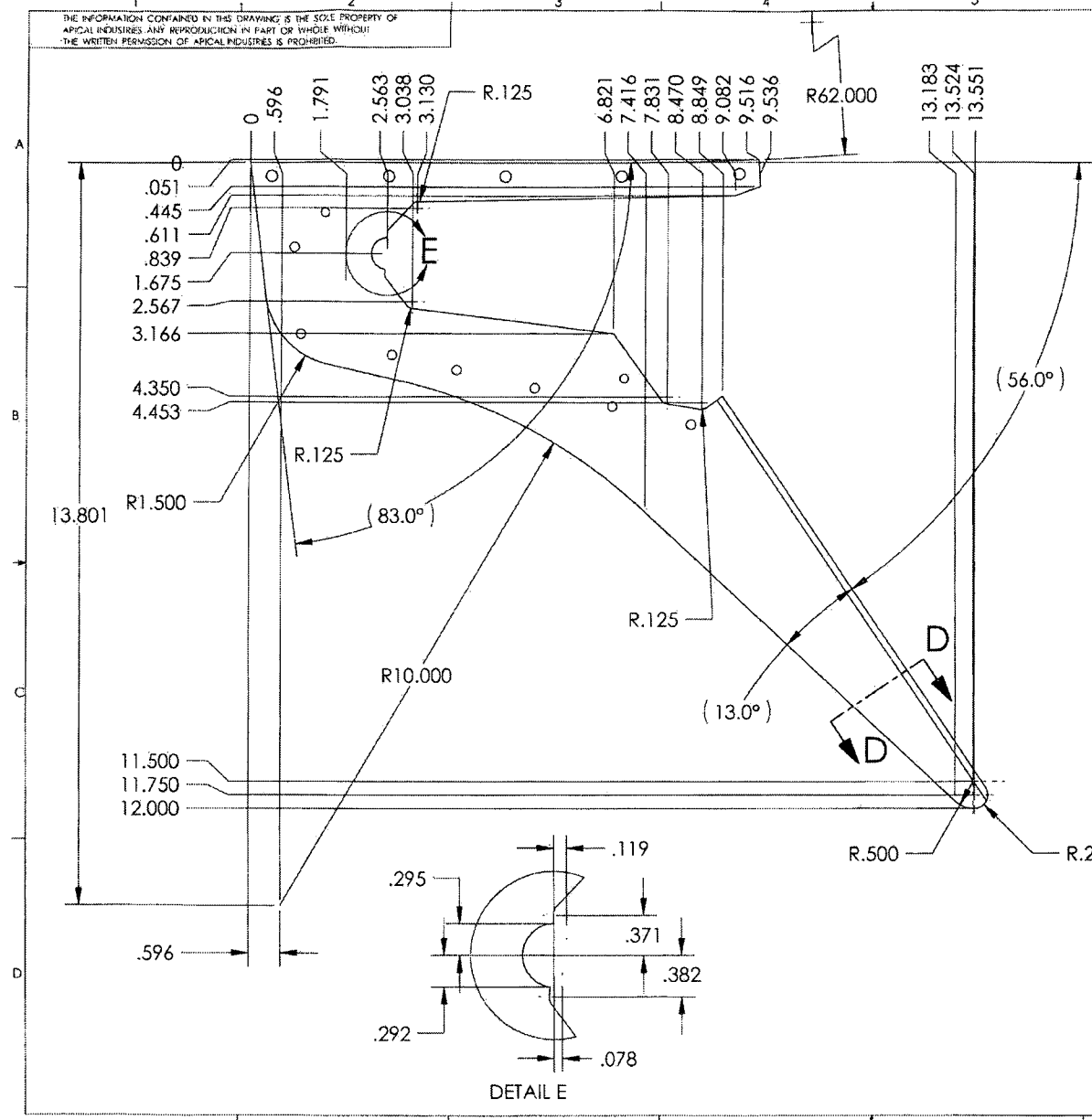
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE (INCHES): 1P: 08-26-06 DRAWN BY: J. JOSEPH CHECKED BY: J. JOSEPH P. RAYDO & J. JOSEPH DRAWING APPROVAL E. JOSEPH 08-26-06 CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
LOWER CUTTER ASSY			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.0°			
SIZE	CAGE CODE	DWG. NO	REV.
B	07M76	646.3000	N/C
SCALE NONE		SHEET	3 OF 8

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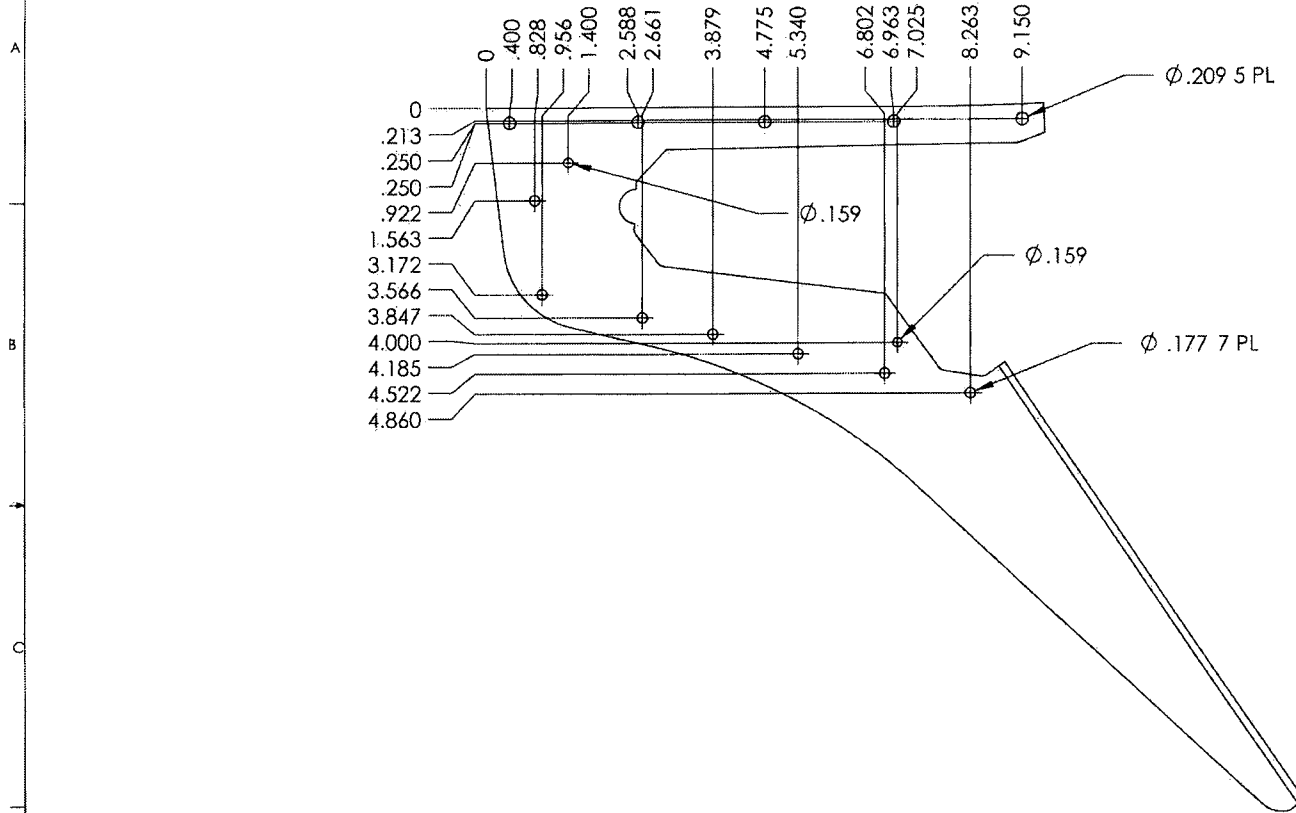
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE: (ISO D-A-Y) 08-24-88 DRAWN BY: J. JOSEPH P. BRAVO DRAWING APPROVAL: J. JOSEPH CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300			
LOWER CUTTER ASSY				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. FRACTIONS .0015 2. DECIMALS .01 3. ANGLES .5°	SHEET 8	CAGE CODE 07M126	DWG. NO. 646.3000	REV N/C
	SCALE NONE		SHEET 4 OF 8	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

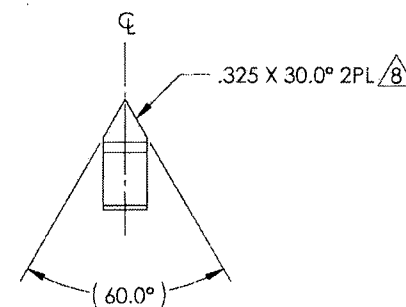
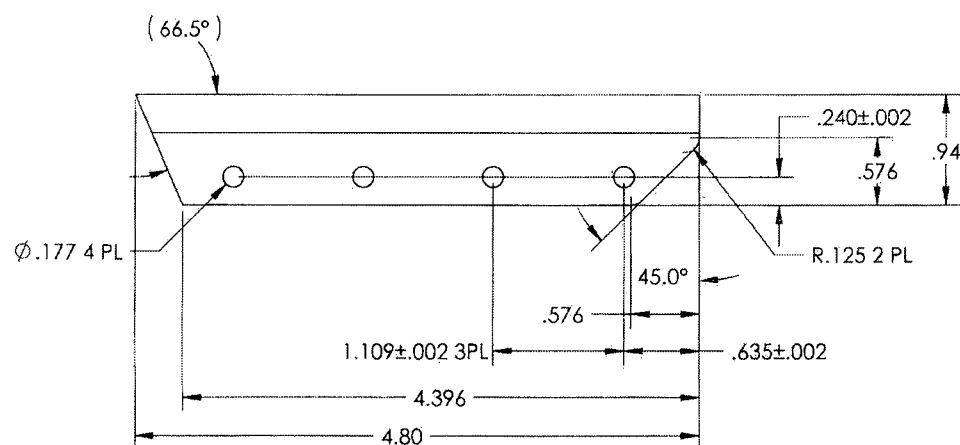
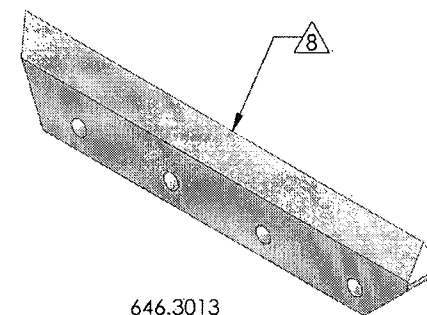
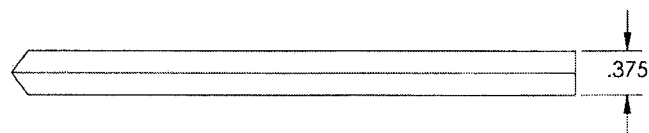


SECTION F-F



ORIGINAL DATE (DD-MM-YY) 08-26-08		APICAL INDUSTRIES	
DRAWN BY P. SPANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. SPANO		LOWER CUTTER ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 ANGLES ± .5°		SIZE B	REV. N/C
		CAGE CODE 07M26	
		DWG. NO. 646.3000	
		SCALE NONE	SHEET 5 OF 8

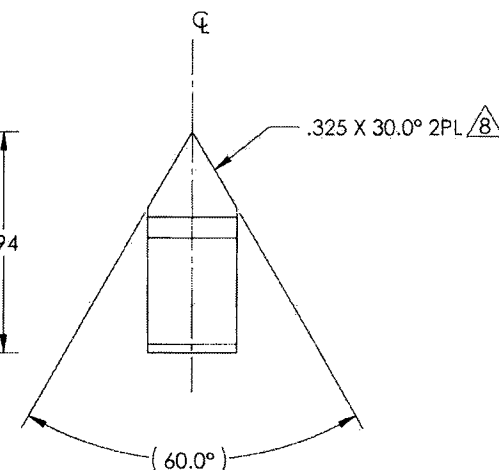
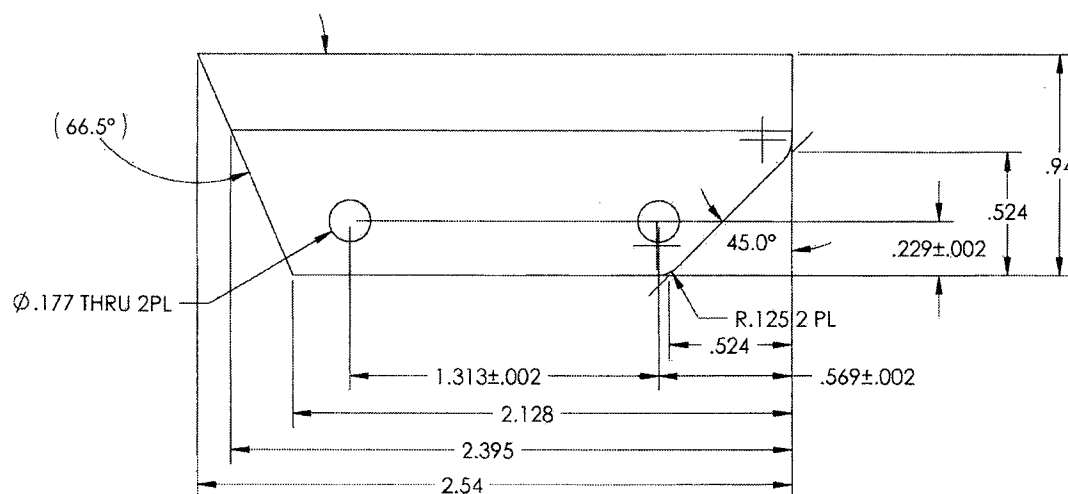
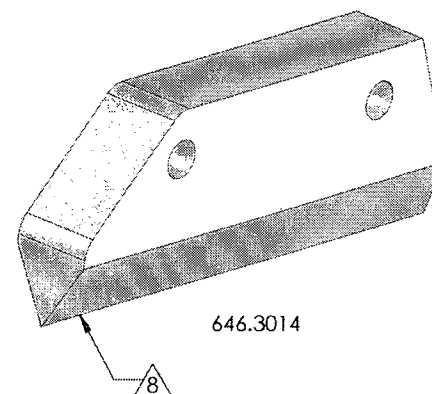
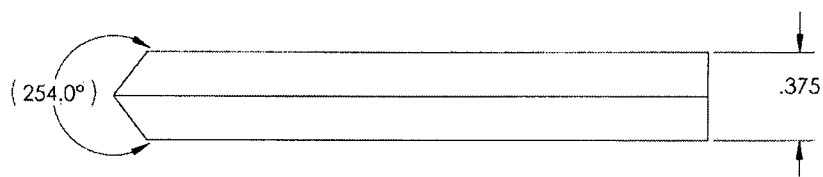
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE (MM-DD-YY) 08-24-08 DRAWN BY J. CROPPER CHECKED BY J. CROPPER DRAWING APPROVAL S. JOSEPH (P) 408-441-1111 CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 774-5300 LOWER CUTTER ASSY												
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. 3 PLACE DECIMALS ± .01 2. 3 PLACE DECIMALS ± .005 3. 3 PLACE DECIMALS ± .003	<table border="1"> <tr> <th>SHEET</th> <th>CAGE CODE</th> <th>REV'S</th> <th>REV</th> </tr> <tr> <td>B</td> <td>07M16</td> <td>646.3000</td> <td>N/C</td> </tr> <tr> <td colspan="2">SCALE NONE</td> <td colspan="2">SHEET 6 OF 8</td> </tr> </table>	SHEET	CAGE CODE	REV'S	REV	B	07M16	646.3000	N/C	SCALE NONE		SHEET 6 OF 8	
SHEET	CAGE CODE	REV'S	REV										
B	07M16	646.3000	N/C										
SCALE NONE		SHEET 6 OF 8											

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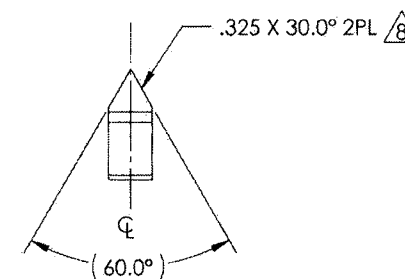
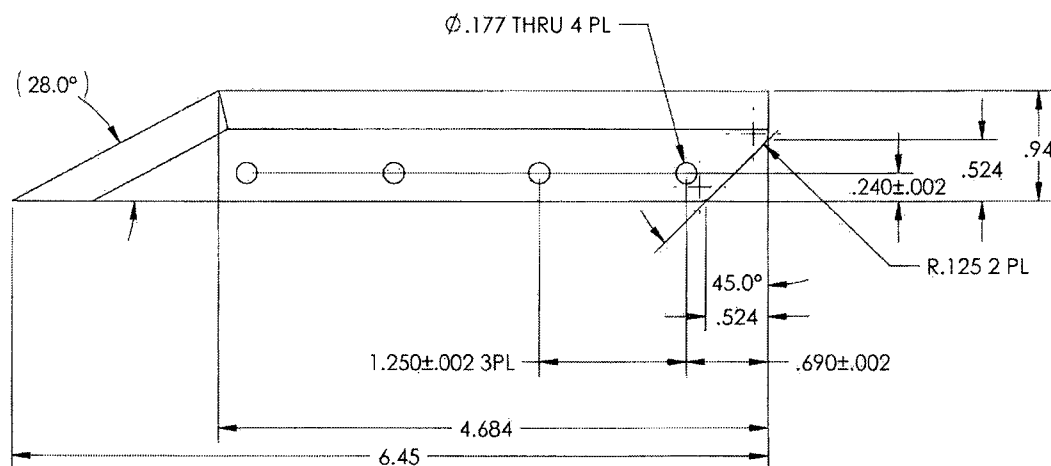
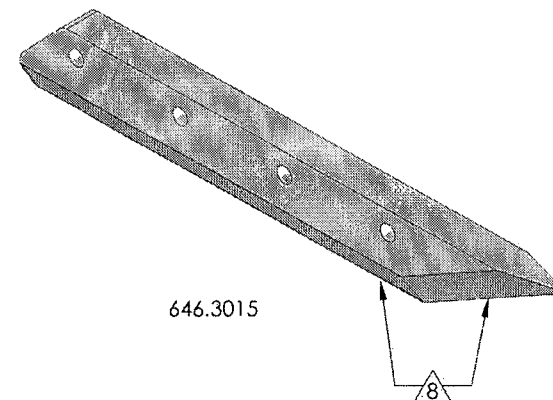
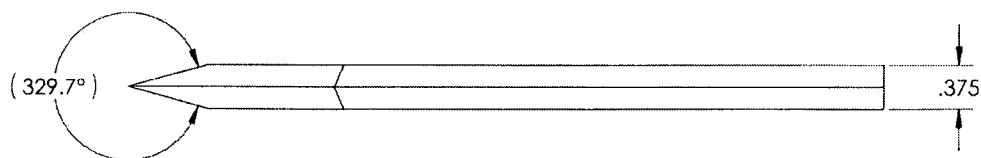
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 08/04/81		APICAL INDUSTRIES	
DRAWN BY P. BRAY		2608 TEMPLE HEIGHTS DR.	
CHECKED BY J. JOHNSON		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL J. JOHNSON		LOWER CUTTER ASSY	
CONTRACT NO.		SHEET 7 OF 8	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	CAGE CODE 07M26
		DATE 07/26/86	REV. N/C
		SCALE NONE	

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REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE (MM-DD-YY) 08-21-98		APICAL INDUSTRIES	
DRAWN BY: J. JOSEPH		2608 TEMPLE HEIGHTS DR.	
P. SPANO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL J. JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEET 8 OF 8	REV. N/C